

Date: Tuesday, 9/19/2006 2:11:50 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : REPLACEMENT WINDOW ASSEMBLY
 Job Number : 28649
 Estimate Number : 11174
 P.O. Number : *N/A* Part Number : D3290041
 This Issue : 9/19/2006 S.O. No. : *N/A* Drawing Number : D3290 REV B
 Prsht Rev. : NC Project Number : N/A
 First Issue : *N/A* Type : SMALL /MED FAB Drawing Revision : B
 Previous Run : 27566 Material : *N/A*
 Due Date : 10/10/2006 Qty: 20 Um: Each
 Written By :
 Checked & Approved By : *06 09.19*
 Comment : Est. B 05/06.25 Added Step 11 KJ/JLM
 Est. C 06.05.09 Ecn 798 EC
 Est Rev:D Now on Waterjet 06-06-16 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M5052H32S040 5052-H32 .040 Sheet



Comment: Qty.: 3.9375 sf(s)/Unit Total : 78.7500 sf(s)

5052-H32 .040 Sheet

(M5052H32S040)

Batch: *1102 723 (18) M101875 (6)*

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3290

Dwg Rev: *B*

Prog Rev: *B*

2-Deburr if necessary

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

5.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #:

Machine Or Operation:

Description:

6.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

FL - / am 07/01/04 (20)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FC 07 01 04 (20)

8.0

D2126

Seal



Comment: Qty.: 6.5000 f(s)/Unit Total: 130.0000 f(s)

Locking Seal

Pick:

Qty Part Number Description Batch

1 D2126-0780 Locking Seal

B27452

9.0

D32901

Window Frame



Comment: Qty.: 0.0000 Each(s)/Unit Total: 0.0000 Each(s)

Window Frame

Pick:

Qty Part Number Description Batch

1 D3290-1 Window Frame

B28649

10.0

D32903

Window



Comment: Qty.: 1.0000 Each(s)/Unit Total: 20.0000 Each(s)

Window

Pick:

Qty Part Number Description Batch

1 D3290-3 Window

B27595
B29568

SP 07/03/15 (20)

11.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D3290

Clean D3290-041 and place in plastic wrap

SP 07/03/17 (20)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: LT Date: 07/03/20
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

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Job Number: 28649

Part Number: D3290041

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/03/19 (20)

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

CU

07/03/20 (20)

14.0

QC21

FINAL INSPECTION/W/O RELEASE



(20)

Comment: FINAL INSPECTION/W/O RELEASE

07/03/20

Job Completion



07/03/20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

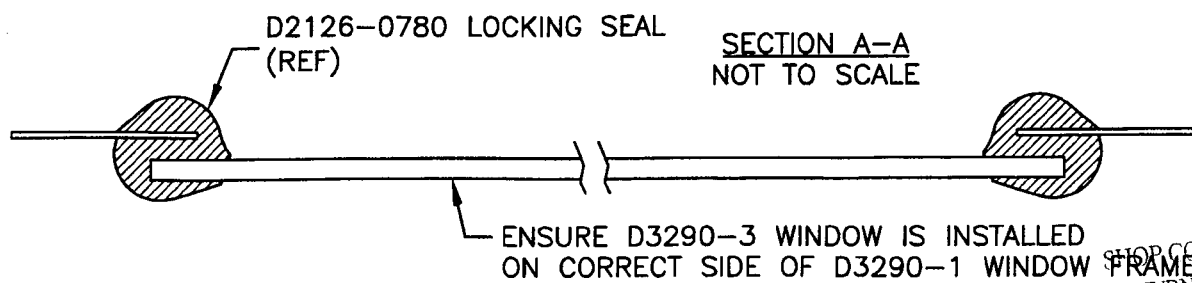
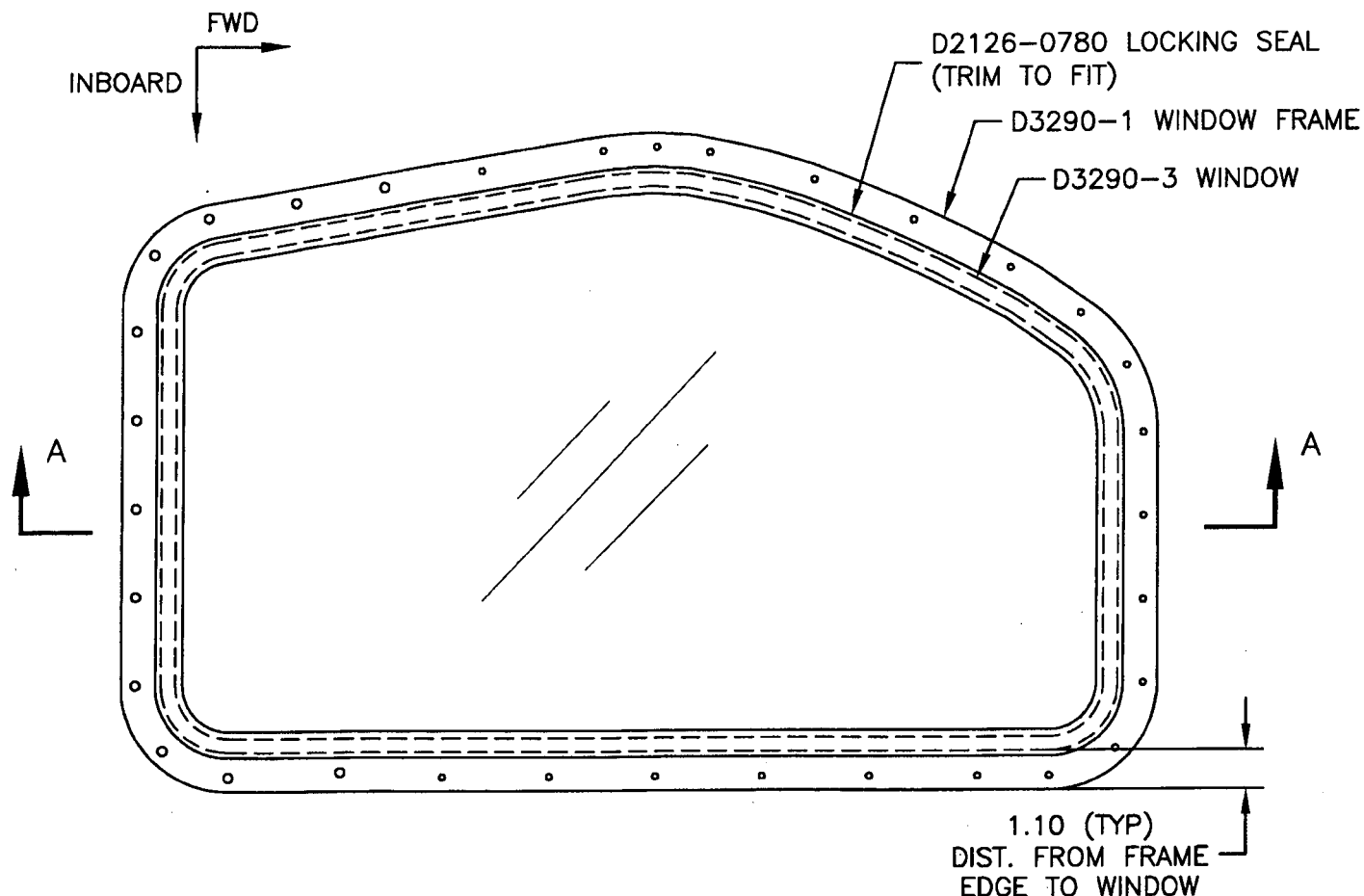
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



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DATE 06.04.20		TITLE REPLACEMENT WINDOW ASSEMBLY	SCALE 1:5
A	04.06.14	NEW ISSUE	
B	06.04.20	UPDATE MATERIAL PER NCR 029	



D3290-041

NOTES

- 1) ALL DIMENSIONS ARE IN INCHES
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

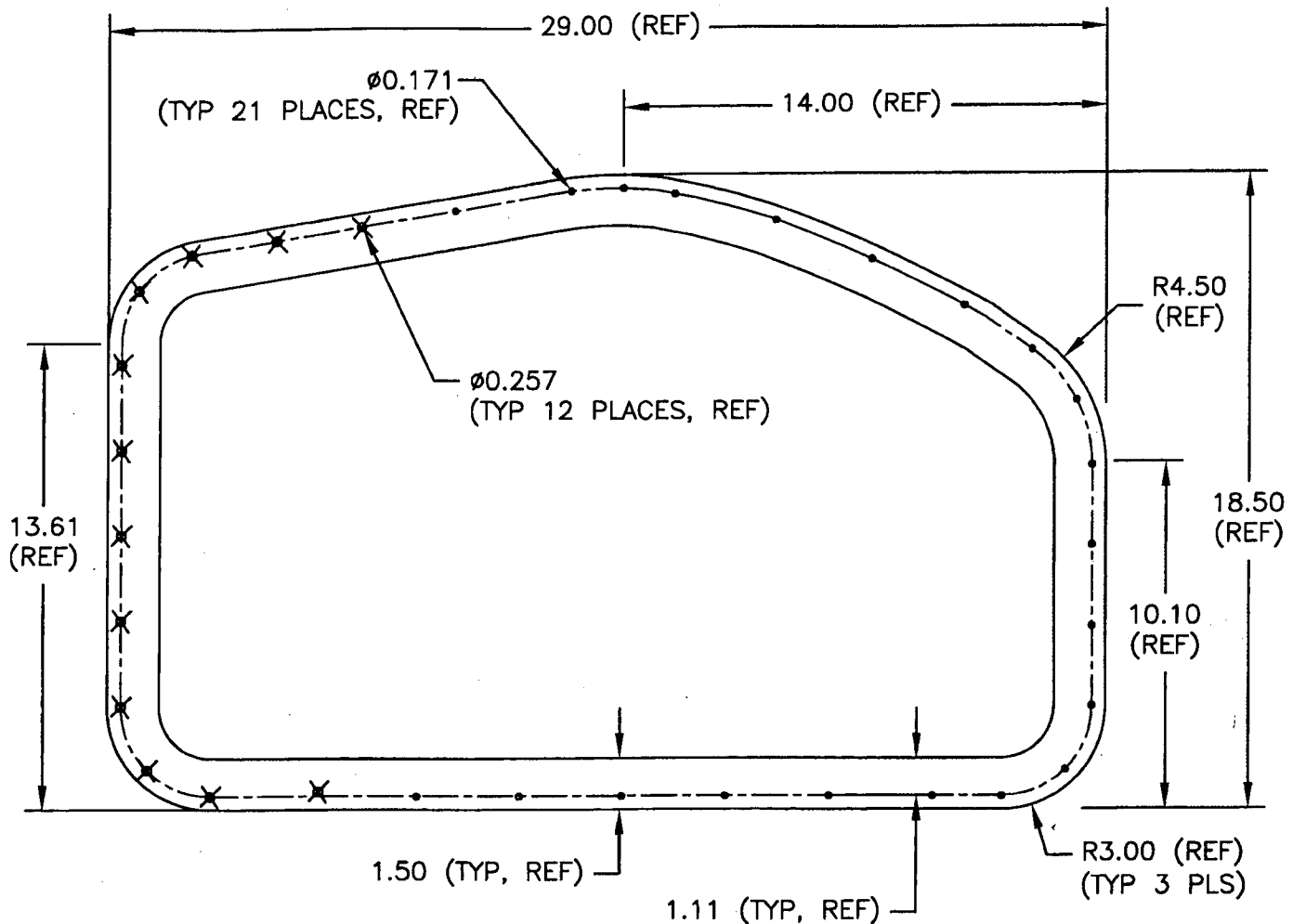
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DATE 06.04.20	TITLE REPLACEMENT WINDOW ASSEMBLY		SCALE 1:5

**D3290-1 FRAME****D3290-1**

- 1) MACHINE PER DRAWING FILE "D3290-A2.DWG"
- 2) MATERIAL: 5052-H32 (QQ-A-250/8) SHEET 0.040 THICK
- 3) FINISH: CHEMICAL CONVERSION COAT PER QSI 005 4.1
POWDER COAT WHITE (REF. 4.5.3.1) PER DART QSI 005 4.1
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

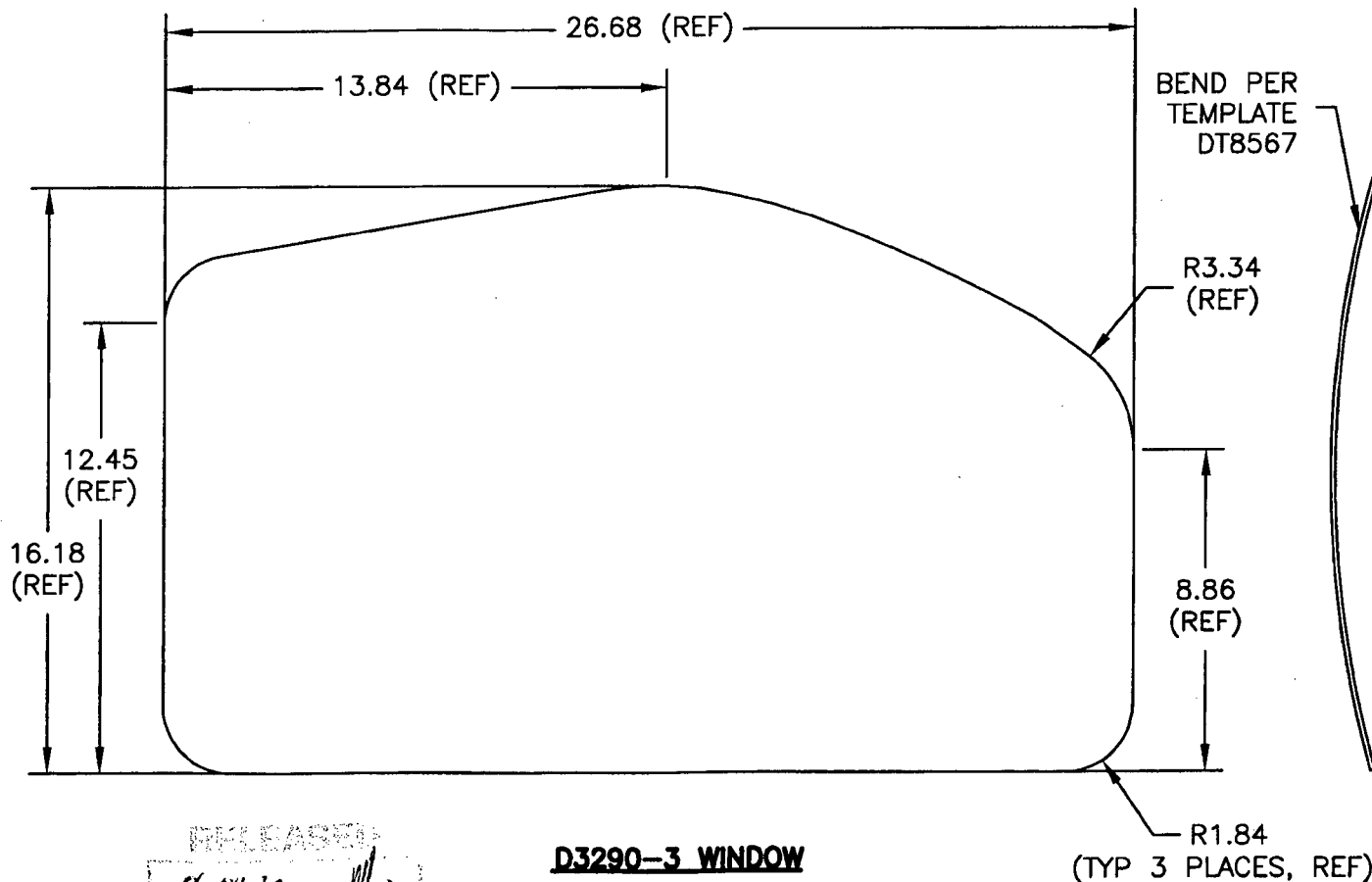
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3290	REV. B SHEET 3 OF 3
DATE 06.04.20		TITLE REPLACEMENT WINDOW ASSEMBLY	SCALE 1:5



D3290-3
B

- 1) MATERIAL: POLYCAST II CLEAR ACRYLIC SHEET PER MIL-P-5425 OR PLEXIGLAS G CLEAR CAST ACRYLIC SHEET PER LP-391 TYPE 1 GRADE C, 0.125 THICK (REF. DART SPEC. M-ACRYLIC-S.125)
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) CHECK PART USING DT3290-3T1

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